

[illegible]

1. Purpose:

This procedure prescribes the methods for splicing the electrical insulation film (Kapton or equivalent) on the cable insulating machine while insulating superconducting cable.

2. Applicable Documents:

12010181                      Insulation, Polyimide Film

3. Requirements:

3.1 Material/Equipment:

PVC gloves (BNL Stock No. K-62646)  
Kingco 15-106-37 General Purpose Adhesive or approved equivalent  
Medical cups (BNL Stock No. I-80567)  
Stirring sticks (BNL Stock No. I-82170)  
Single-edge safety razor blade or equivalent (BNL Stock No. H-32985)  
Kingco adhesive (Vendor Part No. 15-106)

3.2 Procedure: (See Fig. 1)

3.2.1                      Spray adhesive into a mixing cup.

**CAUTION: Do not apply adhesive to bare cable.**

3.2.2                      With a mixing stick, apply adhesive to the cable's upper flat surface over the previously wrapped layer of insulation (Fig. 3.2.2).

3.2.3                      Maintaining the 50% overlap, bring the trailing end of the broken film around cable and press the film into the adhesive with mixing stick (Fig. 3.2.3).

**CAUTION: Do not cut into insulation and/or cable.**

3.2.4                      Using a single edge safety razor blade or equivalent, cut insulation along cable edge while applying tension to insulation. Be sure not to damage cable edge while cutting insulation (Fig. 3.2.4).

3.2.5                      Apply adhesive over the end of the insulation that has just been glued (Fig. 3.2.5).

3.2.6                      Align the leading end of the insulation from the spool allowing overhang (Fig. 3.2.6). Press the film to the adhesive with mixing stick.

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**CAUTION: Do not cut into insulation and/or cable.**

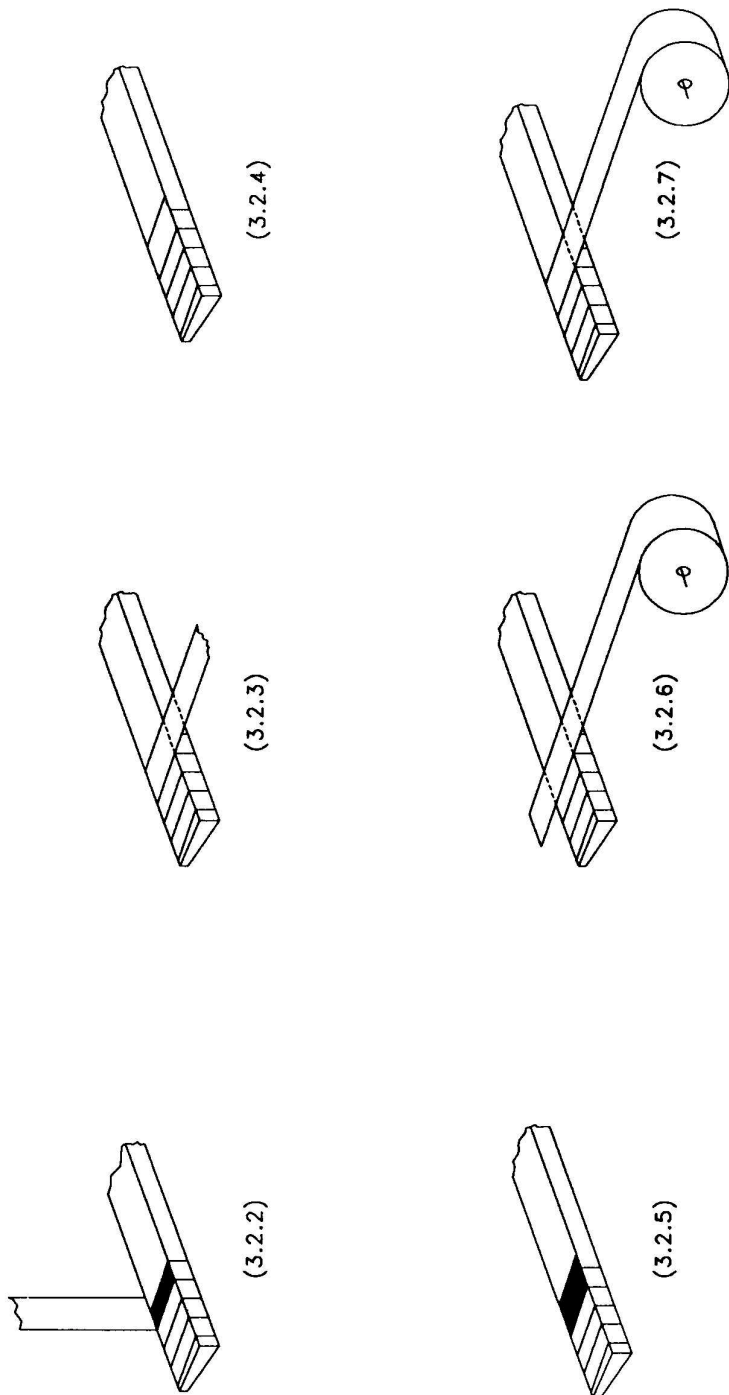
- 3.2.7 While applying tension to overhanging insulation, use razor blade to trim overhanging insulation along edge of cable.
- 3.2.8 Manually rotate the wrapper one full turn prior to restart.
- 3.2.9 Resume cable insulating (RHIC-MAG-R-7155).

4. Quality Assurance Provisions:

- 4.1 The Quality Assurance Provisions of this procedure require compliance with the procedural sequence described herein.
- 4.2 Record all breaks/splices and repairs as prescribed in RHIC-MAG-R-7155.

5. Preparation for Delivery:

N/A



APPLIED ADHESIVE AREA

ON LINE 50% OVERLAP SPLICE  
( FIGURE 1 )